

Green

Dart Aerospace Ltd.

Thursday, 22/01/2009 7:56:38 AM

Melanie Lauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER RESTRAINT WELDMENT
Job Number	: 45031		
Estimate Number	: 13398		
P.O. Number	:	Part Number	: PB674300131
This Issue	: 22/01/2009 S.O. No. :	Drawing Number	: B6743001 P.41/ P.43
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 41377	Material	:
Written By	:	Due Date	: 28/01/2009 Qty: 5 Um: Each
Checked & Approved By	: <u>MF 09-01-22</u>		
Comment	: Est Rev:A 08-06-20 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S090	6061-T6 .090 Sheet
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Comment: Qty.: 0.4557 sf(s)/Unit Total : 2.2785 sf(s)

6061-T6 .090 Sheet

batch: 109184 B 9-2-5

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001-321

Dwg Rev: B1Prog Rev: B1

***grain direction along 25.00" ***

2-Deburr if necessary

B 9-2-5

⑥

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 9-2-5

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 02/02/05 (46)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Bend as per Dwg B67-43001




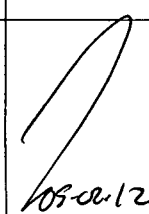
JB 09/02/12 (5)

PTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: B67-43001-31 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: S Date: 09/04/05

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 45031		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/02/12	5	1 piece scrap because tolerance change add .100" more on side D.C. Drawing change.	 R. S. K. M.	Scrap & destroy No replace.	S.B. 09/02/12	 09-02-12	 09-02-12	 09-02-12

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:56:38 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER RESTRAINT WELDMENT

Job Number: 45031

Part Number: PB674300131

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/12 (x5)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

98

09-02-12 (x5)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

M102316

(5x)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:20
0 F
320
11:50

M/L 09/02/14

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/06 (5)

10.0

PB674300133

Upper Pad Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Upper Pad Assembly

batch: 641505

FL

11.0

NAS1149F0316P

WASHER



Comment: Qty.: 5.0000 Each(s)/Unit Total: 25.0000 Each(s)

WASHER

batch: m111124

FL

12.0

MS27039109

Screw



Comment: Qty.: 5.0000 Each(s)/Unit Total: 25.0000 Each(s)

Screw

batch: ~~m101376~~ m18057 (x20) m18106 (x5)

FL 09/04/06

(R10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
02/04/06	12.0	Change screw MS270391-08 for screw MS270391-07.	FL	02/04/06	25			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 7:56:39 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UPPER RESTRAINT WELDMENT

Job Number: 45031

Part Number: PB674300131

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per dwg B67-43001

FD 09/04/06

(5)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/01/07 (5)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 443

9/4/7

(5)

SD

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/07

Job Completion



MF 09-04-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

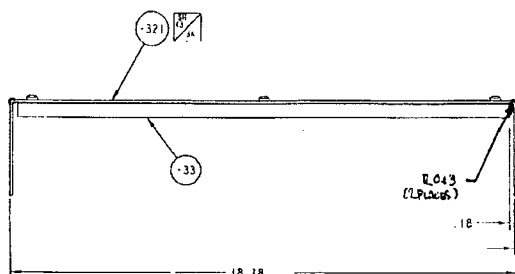
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

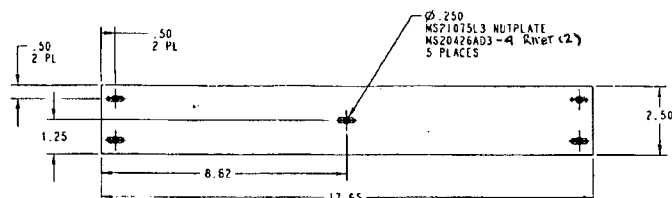
RELEASED
11/01/20



Ø .193 THRU
MATCH DRILL WITH
EXISTING NUTPLATE
LOC'S OF -33
MS27039 1.09 SCREW
NAS11491 Ø316P WASHER
5 PLACES

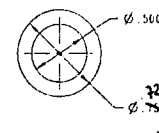


① -31 UPPER RESTRAINT WFLDMNT
SCALE 0.500

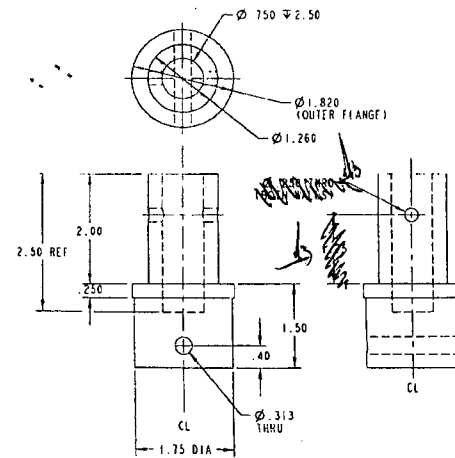


① -33 UPPER PAD ASSY
SCALE 0.500
MATL FOR -375: .032 THK 2024-T3 AL.
00-A-250/4

3.60
ACCEPTED
100.0212



① -299 DUSHING
SCALE 2.000
MAT: 304 CRES. COND A



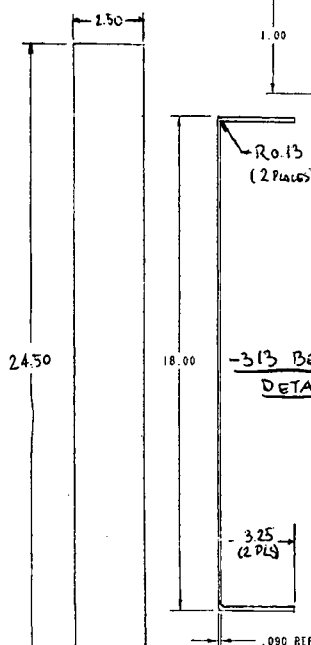
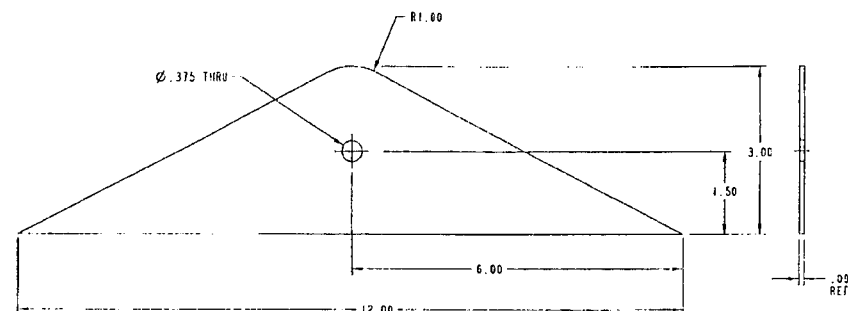
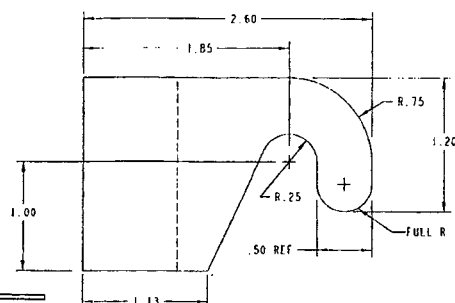
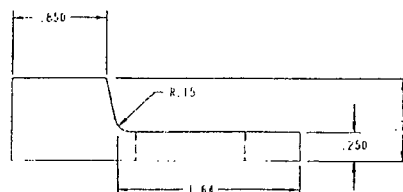
① -305 BEARING
SCALE 1.000
MAT: 2024-T3 AL.
00-A-200/3

45031

PREMIER AVIATION, INC.
2001 Aviation Parkway, Grand Prairie, Texas 75050
REV: 0001 02-07-00
D: OSUV8
B67-43001
B4

ORIGINAL

RELEASED
20-11-20

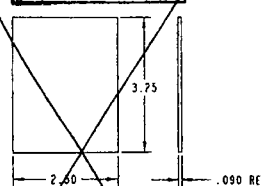


③ -315 HOOK
SCALE 2.000
MAT: 6061-T6 AL.
OO-A-20078
XLM

-313 BENDING
DETAIL

SUPERCEDED BY

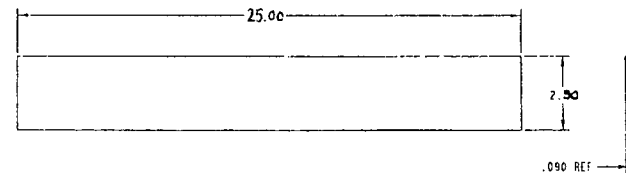
NEW PART OF -317



② -317 PLATE
SCALE 0.750
MAT: 6061-T6 AL.
OO-A-20078

② -319 GUSSET
SCALE 1.000
MAT: 6061-T6 AL.
OO-A-20078

45031



① -321 PLATE
SCALE 0.500
MAT: 6061-T6 AL.
OO-A-20078

① -313 FLAT PATTERN
SCALE 0.500
MAT: 6061-T6 AL.
OO-A-20078

PREMIER AVIATION, INC.
9801 Aviation Parkway, Grand Prairie, Texas 75050
PART CODE: 10001-00
D10SUV81 867-43001
SCALE: 1"=1" SHEETS: 43 OF 45

ORIGINAL

